

How Split

Work Order ID 83936-2

Tuesday, May 29, 2012 8:55:03 AM

83936

Page 1

Item ID: D3204-041

Revision ID:

Accept

N900040100

Setup Start *NS1*

Item Name: Release Pedal Assembly

Start Date: 4/27/2012 Start Qty: 3

Stop *NS2*

Required Date: 5/11/2012 Req'd Qty: 4.00

4
4

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MF
QC:

Date: 12-05-29

Tooling:

Run Start *NR1*

Date:

SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

100

Large Fab

Large Fab

0.00

Large Fab

Memo

0.00

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
2- Drill #40 diameter hole in the center of 00.760" c'hole on D3204-5 arm prior to weld.
3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

110

110

QC

Quality Control

QC 9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4

12-06-29

12-06-29

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Tuesday, May 29, 2012 8:55:03 AM

Item ID: D3204-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Release Pedal Assembly

Start Date: 4/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC 5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

Hand Finish

Memo

0.00

Hand Finishing

140

Grey Sandtex (Ref: 4.3 5.6) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

Cover holes for bushing

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:31
320
12:22

11

11/06/12

14

11/12/12

14

11/12/12

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Page 3

Tuesday, May 29, 2012 8:55:03 AM

Item ID: D3204-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Release Pedal Assembly

Start Date: 4/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

QC 12/06/28

160

Small Fab

0.00

160

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

3x

9/12/06/28

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

3

SB 12/06/28

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Page 4

Tuesday, May 29, 2012 8:55:03 AM

Item ID: D3204-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Release Pedal Assembly

Start Date: 4/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location

GA

0.00

180

Packaging

Memo

0.00

Packaging

3

8/12/6/28

190

QC 21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/6/29
ME
12-06-28

Picklist Print

Tuesday, May 29, 2012 8:55:02 AM

Page 1

Work Order ID: 83936

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/27/2012

Required Date: 5/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11 Added Step 25 KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|----------------|--------------|---------------|----------------|--------|
| D3204-1 Tube | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 4 | | 12-6-20 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA021 | | 4 | | | | | | | |
| | | | | 79294 | | 4 | | | | 4 | | | |
| D3204-11 Plate | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 4 | | 12-6-20 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA021 | | 8 | | | | | | | |
| | | | | 57527 | | 8 | | | | 8 | | | |
| D3204-13 Gusset | | Manufactured | No | | | 100 | Each | 14.0000 | 2 | 8 | | 12-6-20 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA021 | | 14 | | | | | | | |
| | | | | 70315 | | 3 | | | | | | | |
| | | | | 73465 | | 11 | | | | 8 | | | |
| D3204-3 Arm | | Manufactured | No | | | 100 | Each | 13.0000 | 1 | 4 | | 12-6-20 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA019 | | 13 | | | | | | | |
| | | | | 79801 | | 13 | | | | 4 | | | |
| D3204-5 Arm | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 4 | | 12-6-20 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA021 | | 4 | | | | | | | |
| | | | | 79292 | | 4 | | | | 4 | | | |

Picklist Print

Tuesday, May 29, 2012 8:55:02 AM

Page 2

Work Order ID: 83936

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/27/2012

Required Date: 5/11/2012

Start Qty: 4.00

Required Qty: 4.00

| | | | | | | | |
|---------|--------------|----|-----|------|--------|---|----------|
| D3204-9 | Manufactured | No | 100 | Each | 7.0000 | 1 | 4 |
| Pedal | | | | | | | EL 12670 |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

WA020

7

79803

7

D3204-7

Manufactured

No

160

Each

7.0000

2

8

Bushing

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

GA

7

77091

1

79802

6

6

Tuesday, May 29, 2012 8:55:02 AM

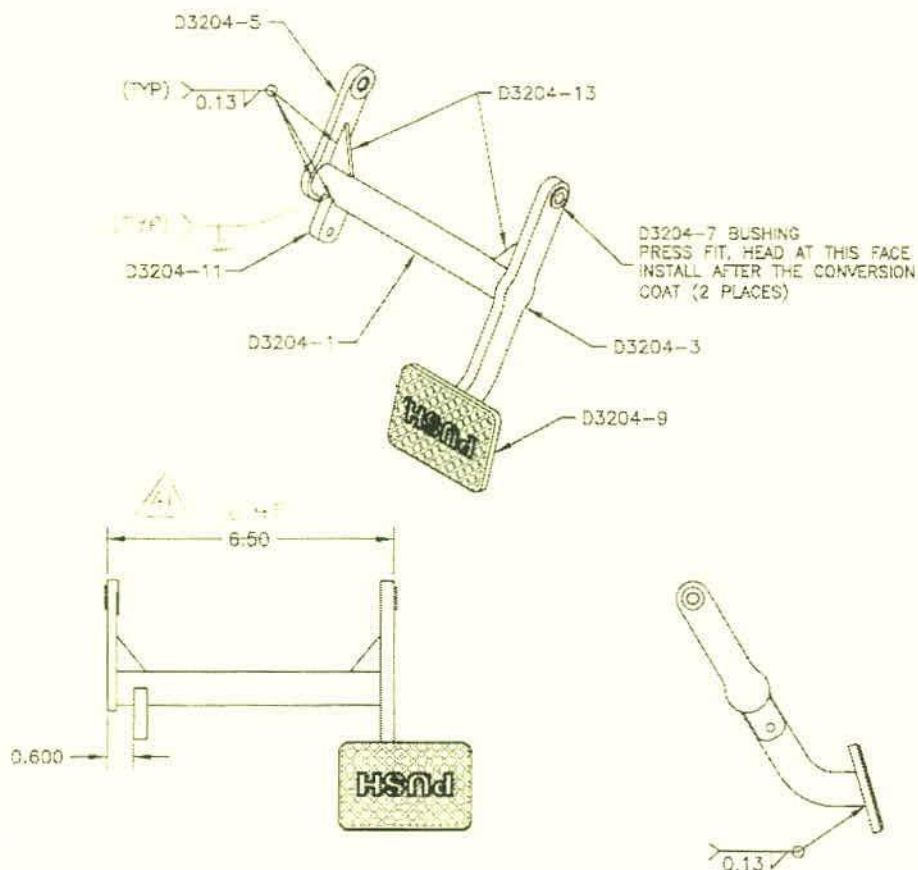
Shop Packet Print

Page 2



| | | | |
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| A | 04.01.27 | NEW ISSUE | |

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D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

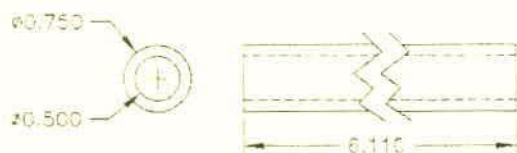
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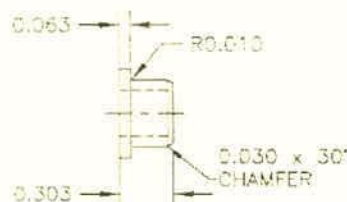


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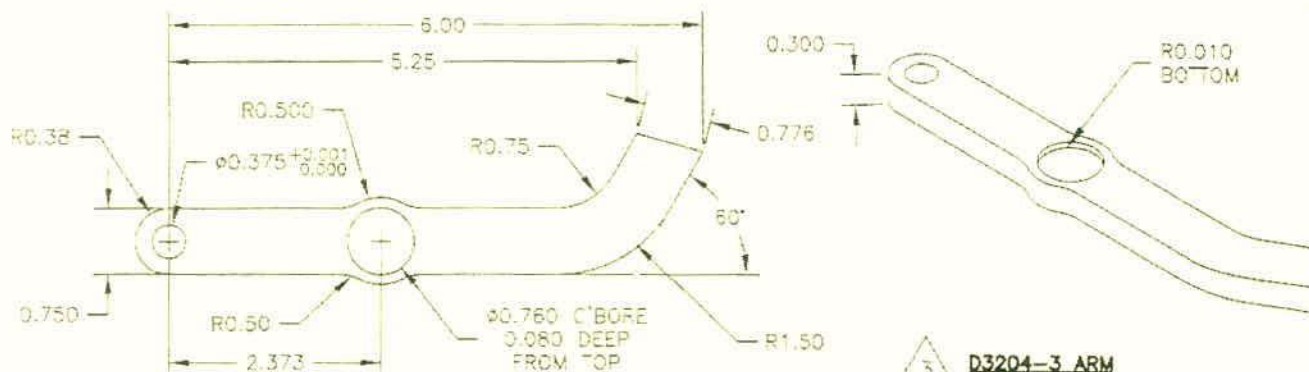
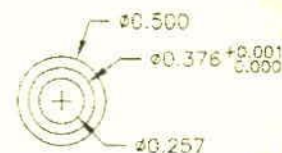
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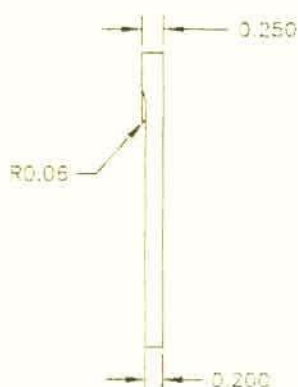
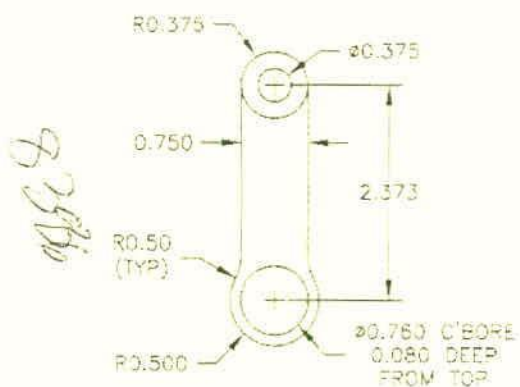
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2

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